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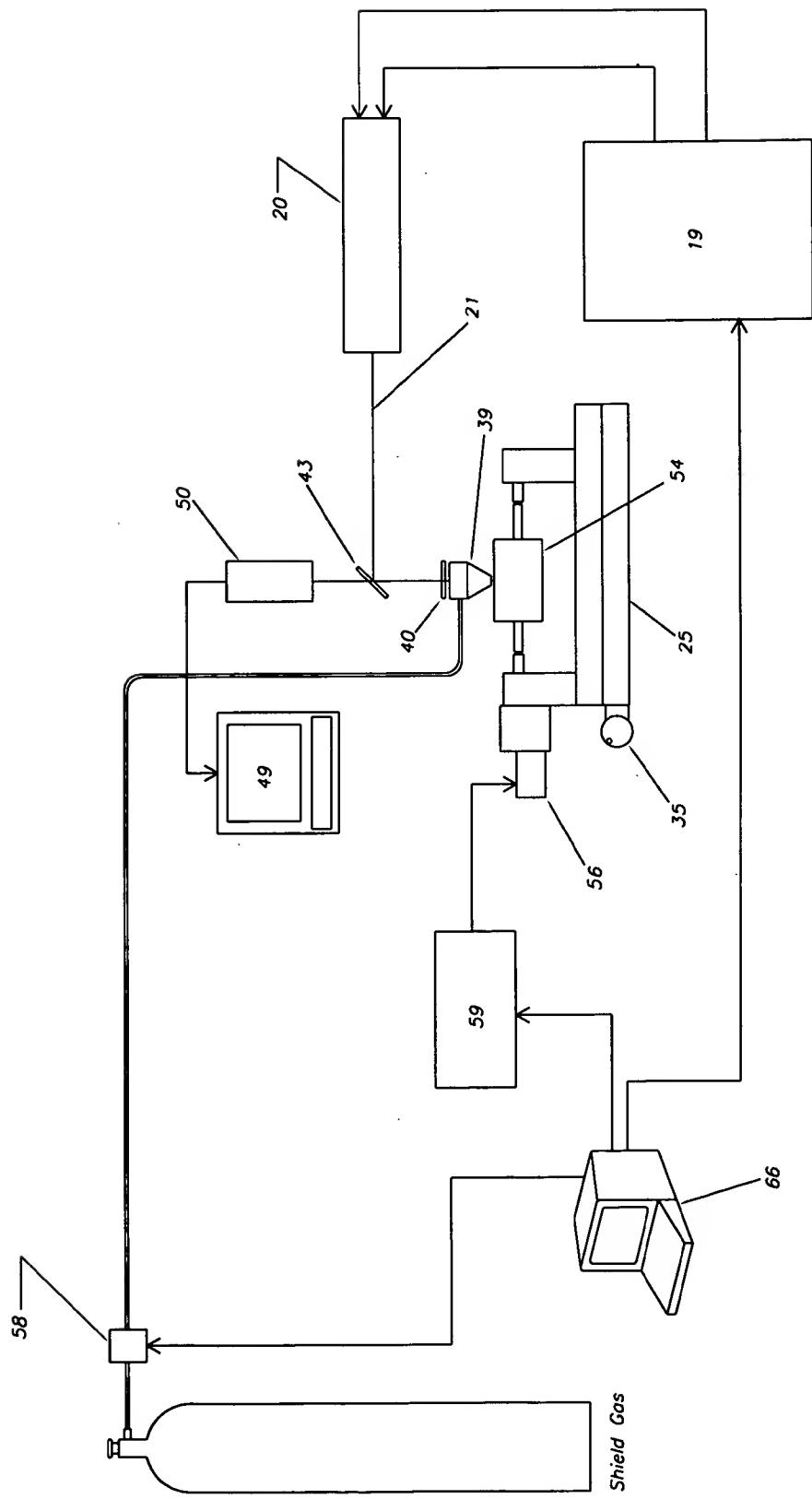


FIG. 1

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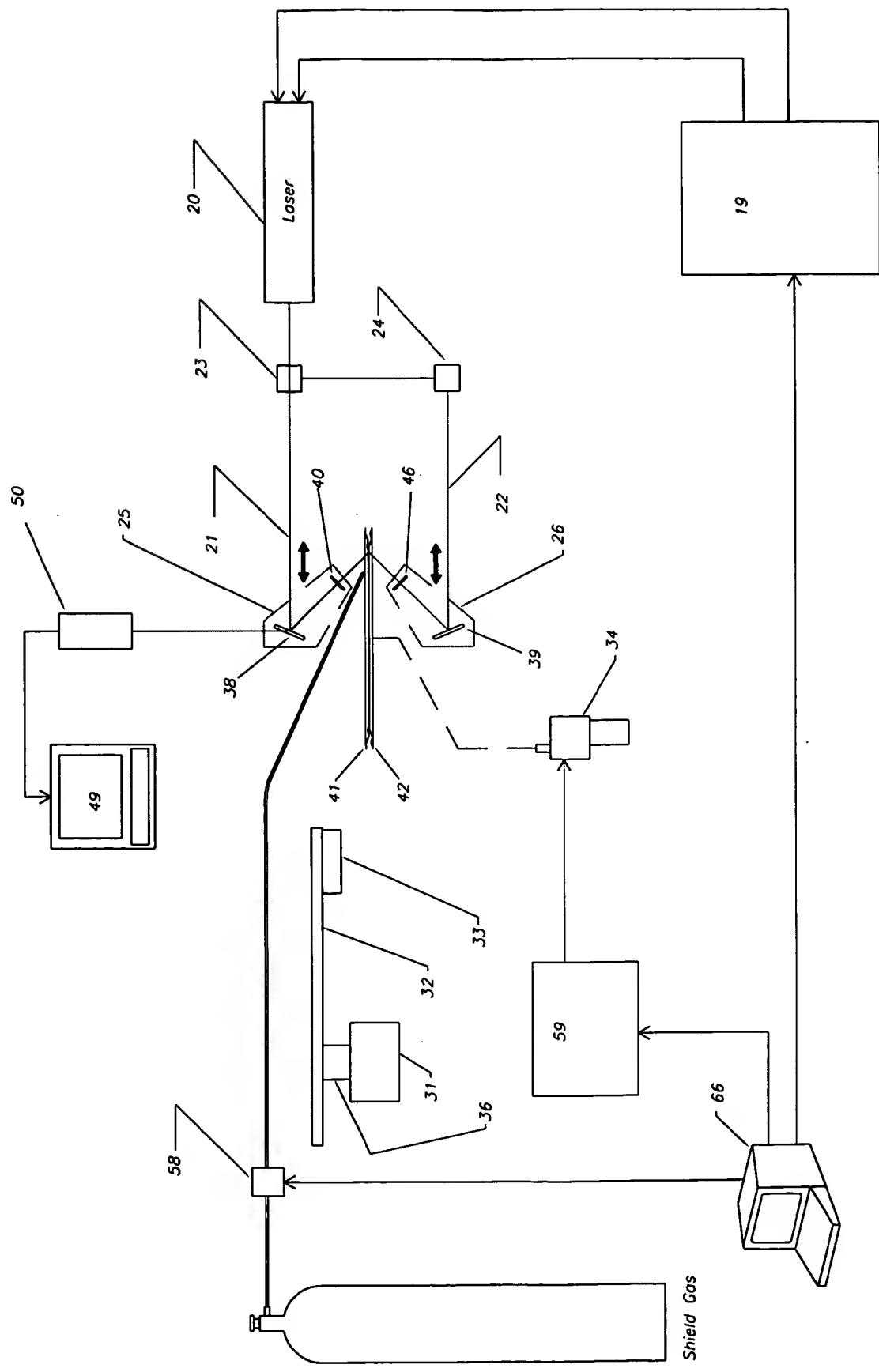


FIG 2

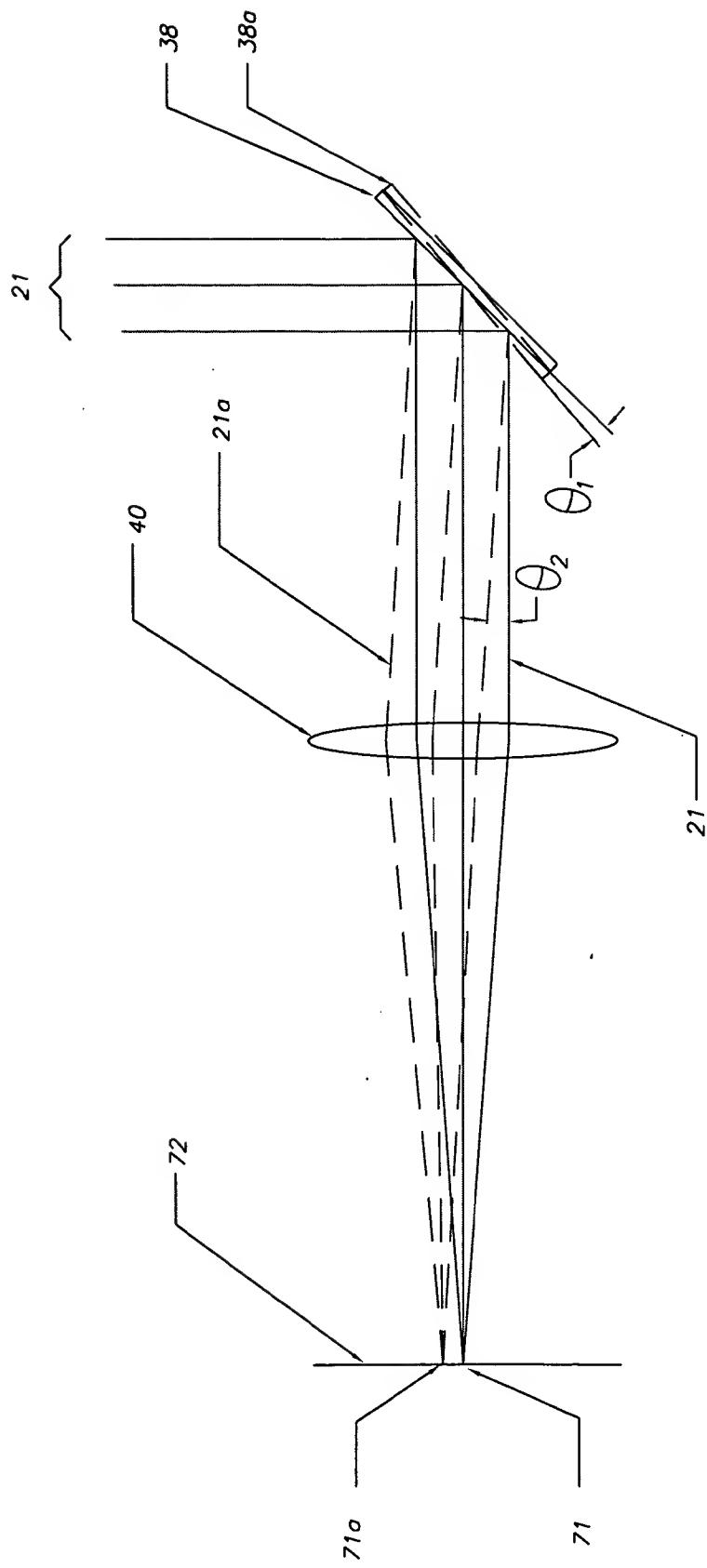


FIG 3

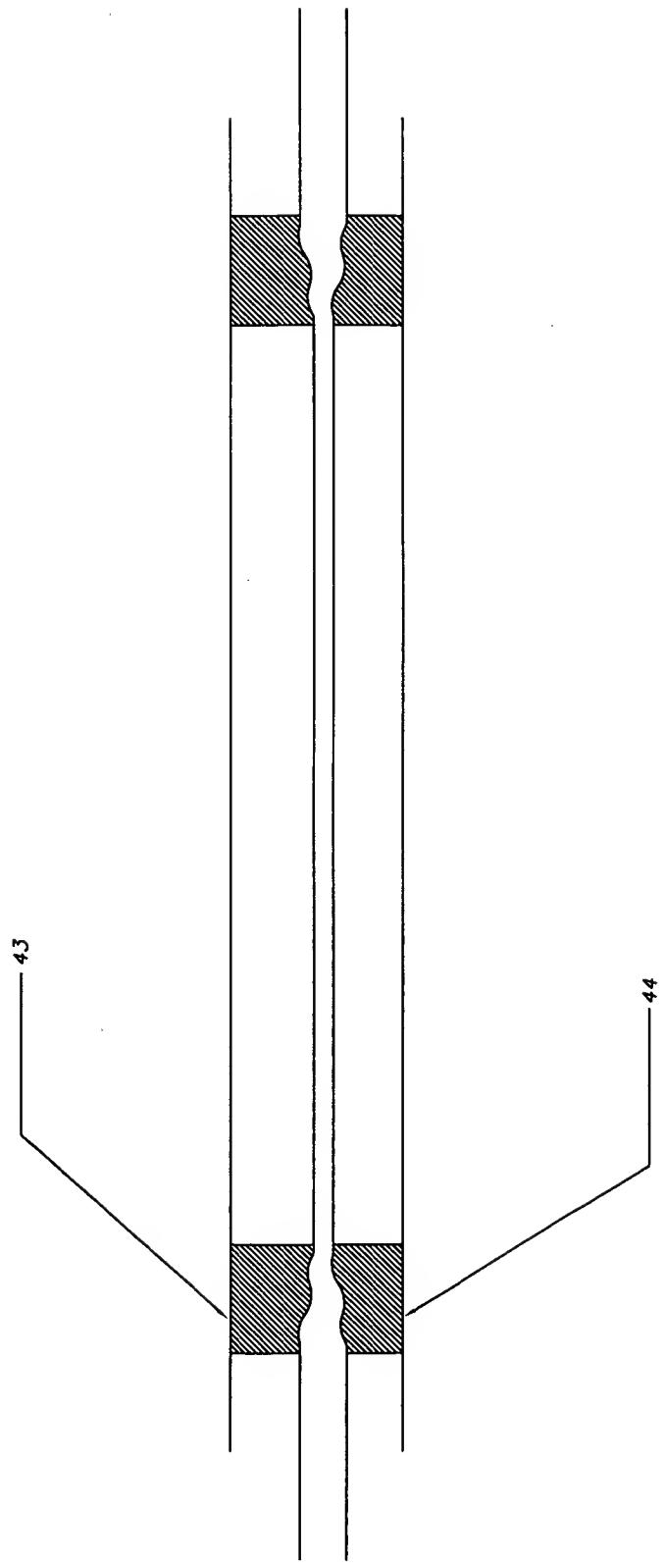


FIG 4

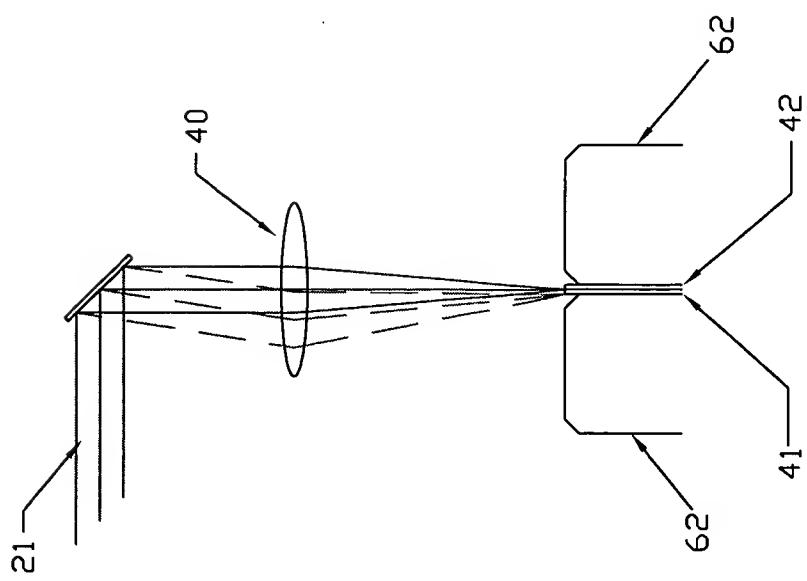


FIG 5A

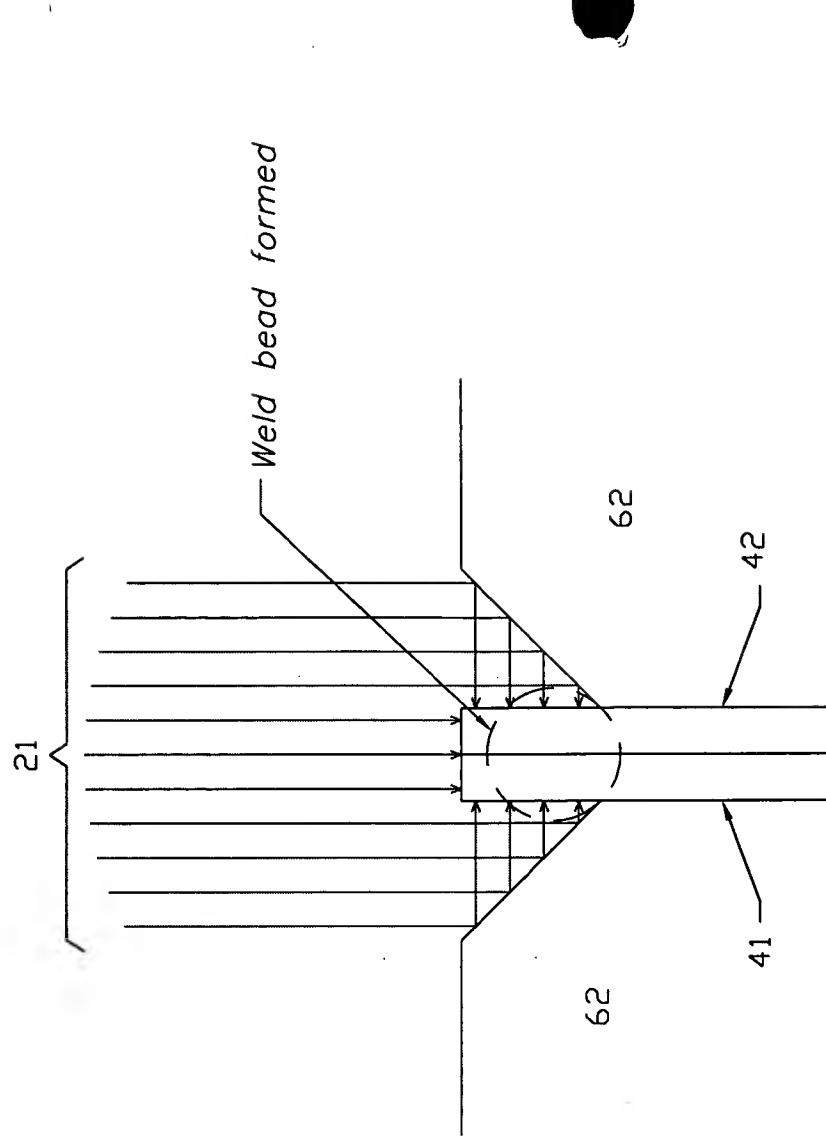


FIG 5B

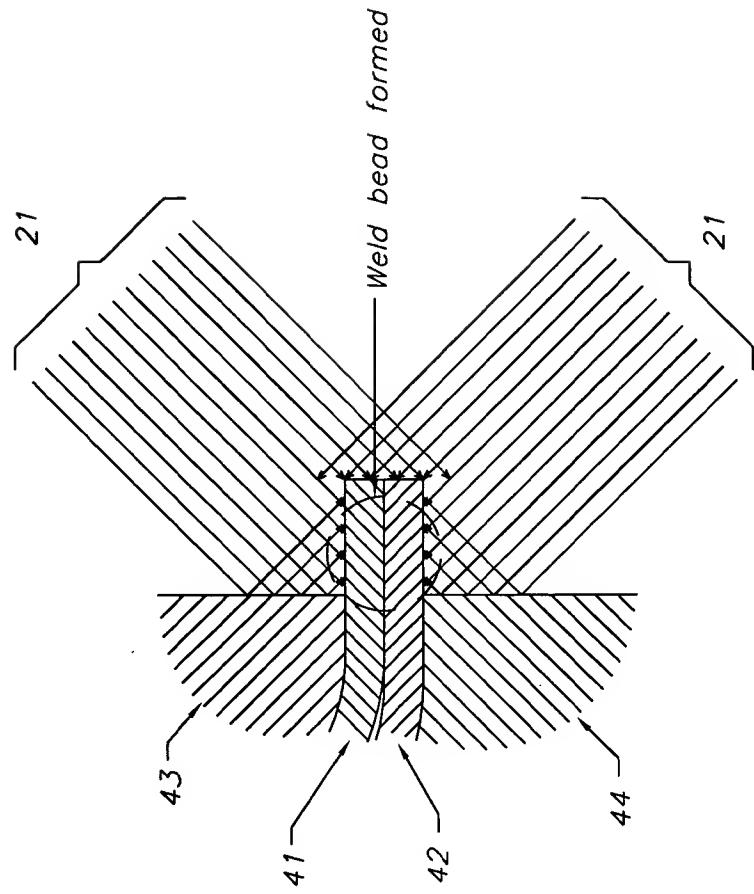


FIG. 6B

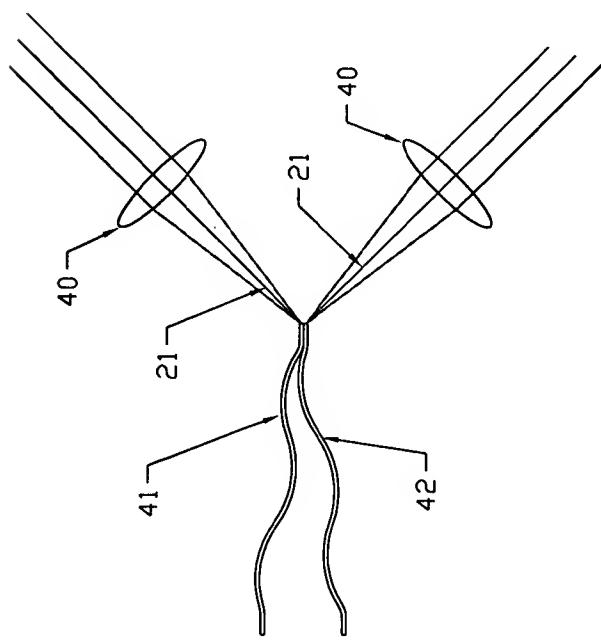


FIG. 6A

FIGURE 7. FIGURE 7.

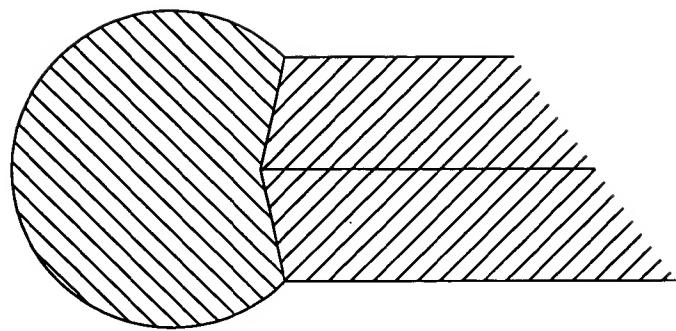


Fig. 7B

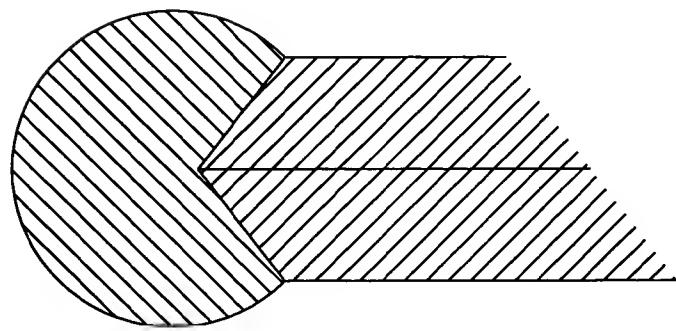


Fig. 7A

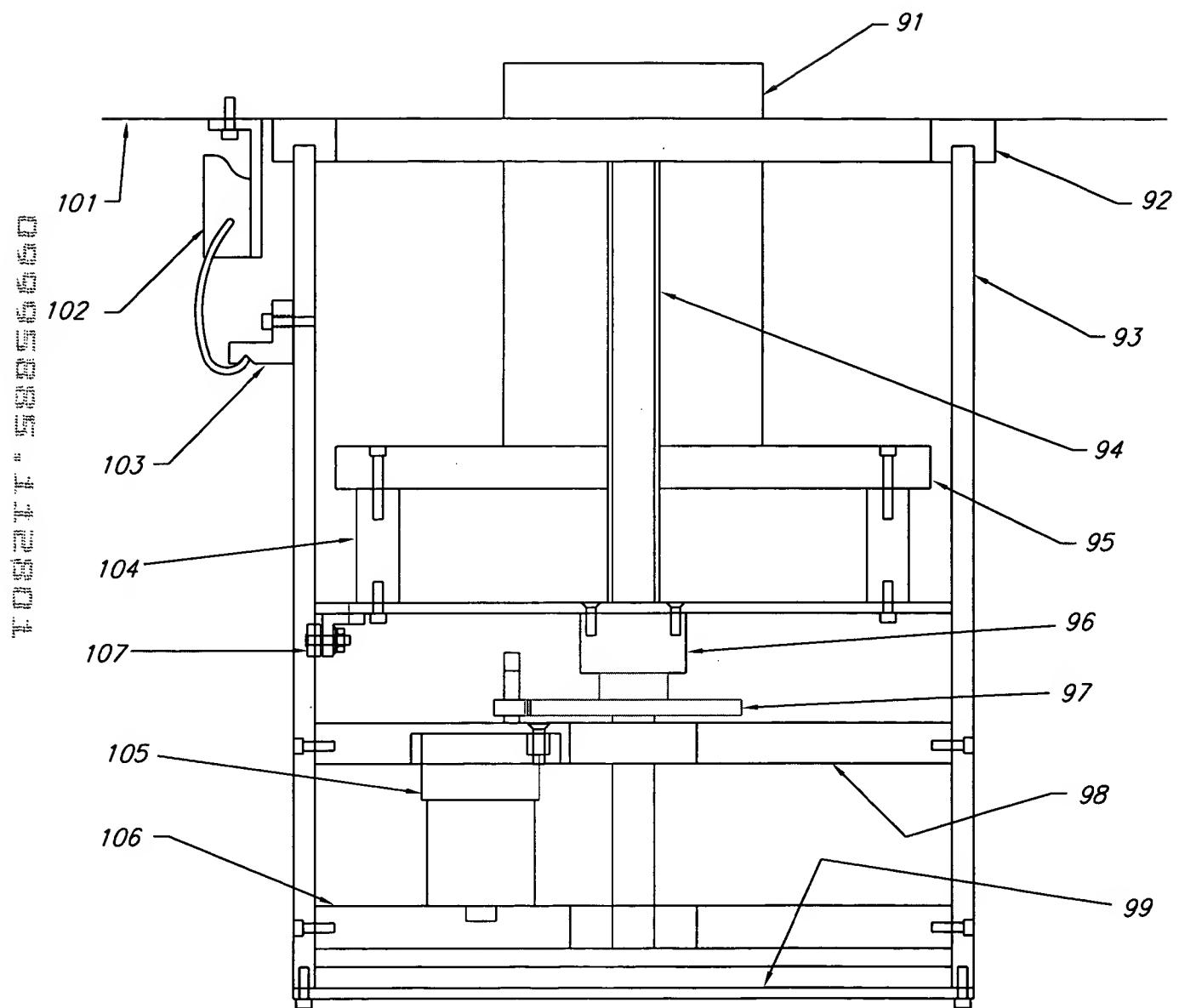
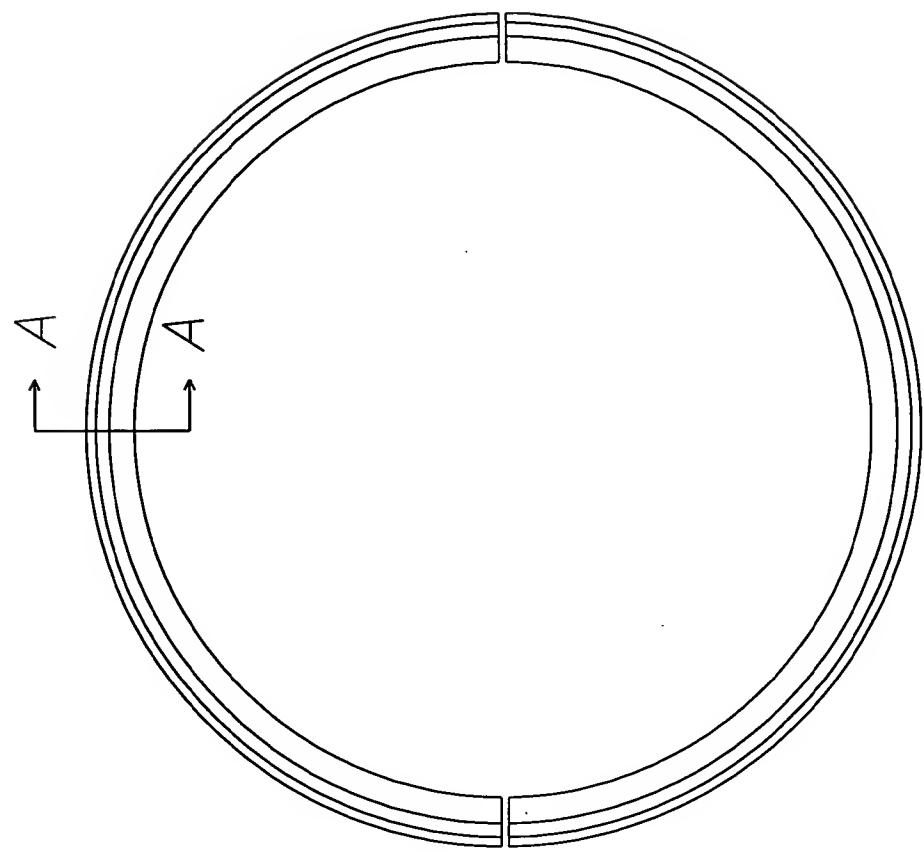


Fig. 8



Section A-A

FIG 9A

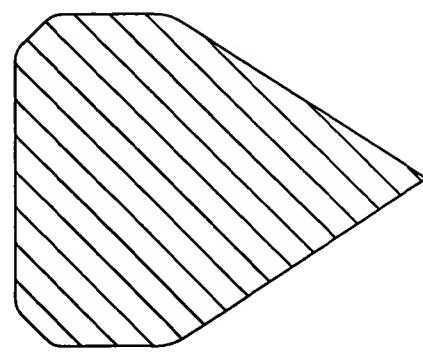


FIG 9B

*Molten beads may not run together,
forming incomplete weld*

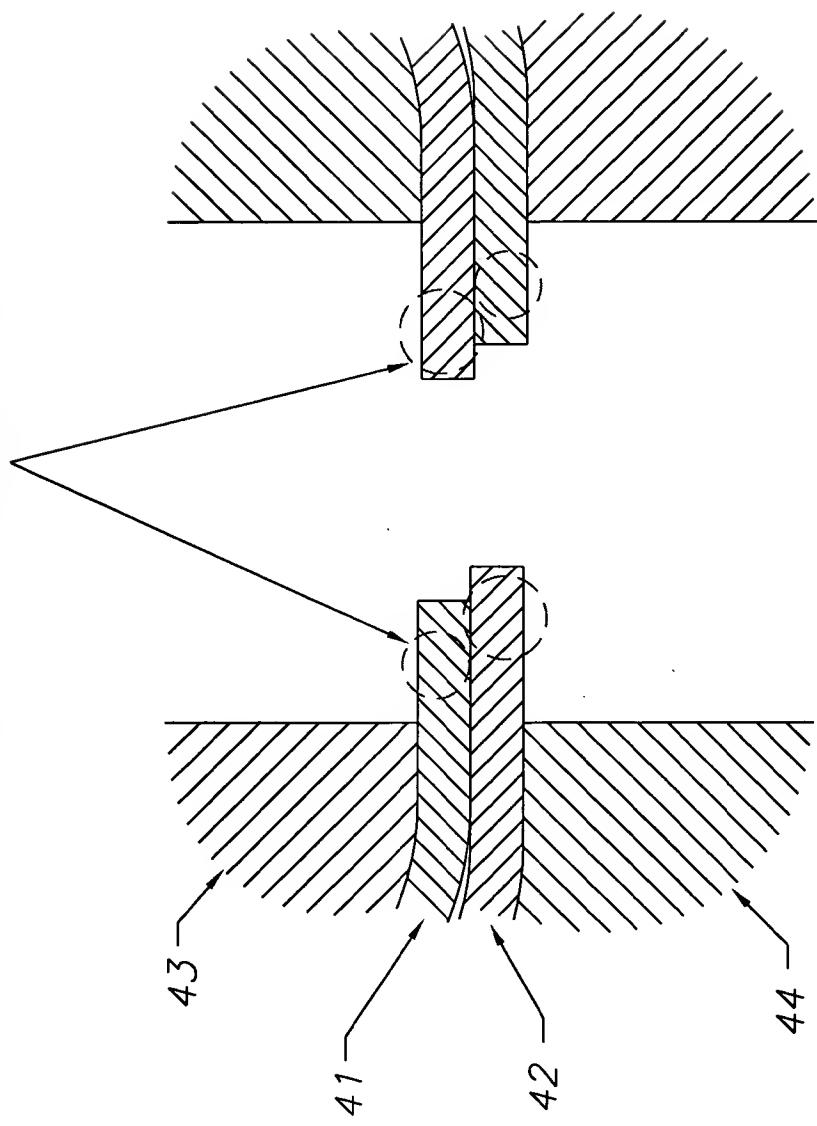
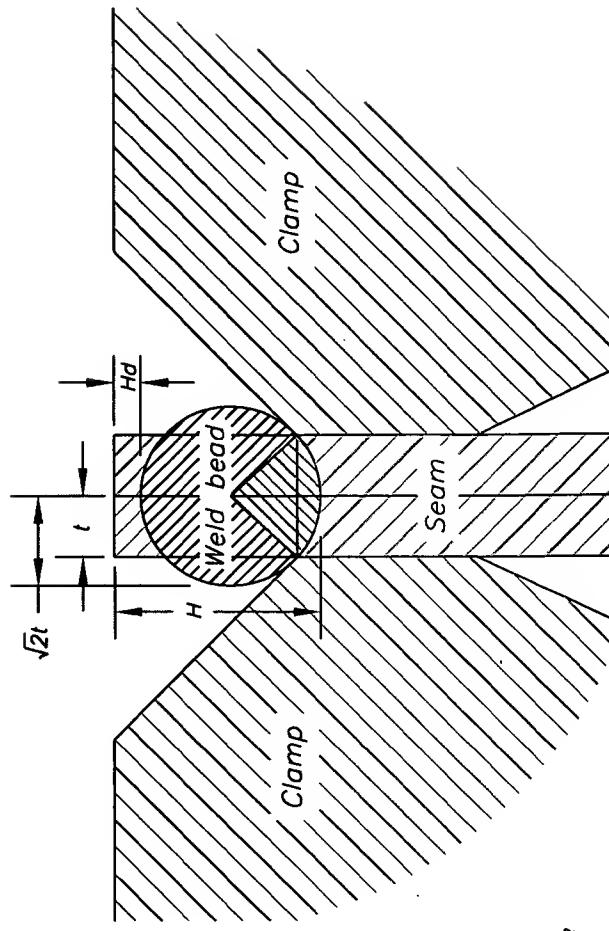


FIG 10



$$\text{Area of Circle} \\ Ac = 2\pi * t^2$$

$$\text{Area of Triangle} \\ At = t^2$$

$$\text{Area of Pie}$$

$$Ap = 1/4 \ Ac - At \\ = 1/2\pi * t^2 - t^2$$

$$\text{Welded area } (Ac - Ap) \\ Aw = 2\pi*t^2 - 1/2\pi*t^2 + t^2$$

$$\therefore H*2t = Aw \\ H = \frac{3/4\pi*t^2 + t^2}{2t}$$

$$H = \left(\frac{3}{4}\pi + 1/2 \right) t$$

$$H = 2.856t$$

$$Hd + \sqrt{2*t} + t = H \\ Hd = H - \sqrt{2*t} - t$$

$$Hd = 0.441t$$

Fig. 11